

## 03-040 Replacement of core hole caps in crankcase

### Shop-made tool

Installer for caps

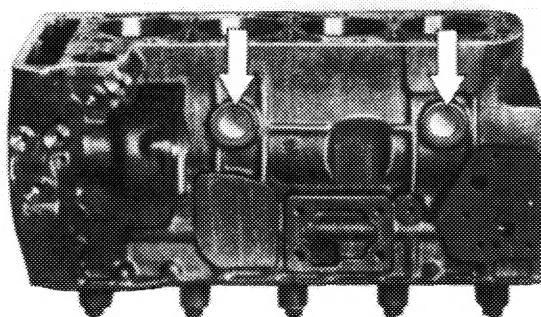
see illustration, job No. 11

### Note

The core holes in the crankcase are closed by metal caps (34 mm dia.).

Leaking caps must always be replaced.

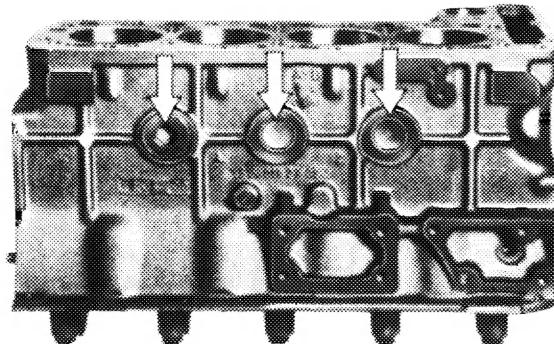
One screw plug (M 38 x 1.5) has been retained at the right-hand side (straight-ahead).



Crankcase, engine 615  
Straight-ahead left

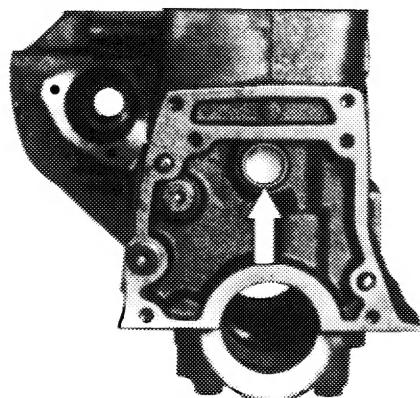
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This core hole will accept a coolant preheater.



Crankcase, engine 615  
Straight-ahead right

103-13400



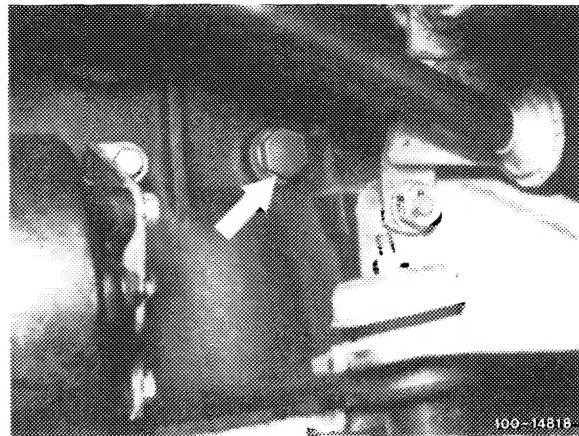
Crankcase, engine 615  
Transmission end

103-13399

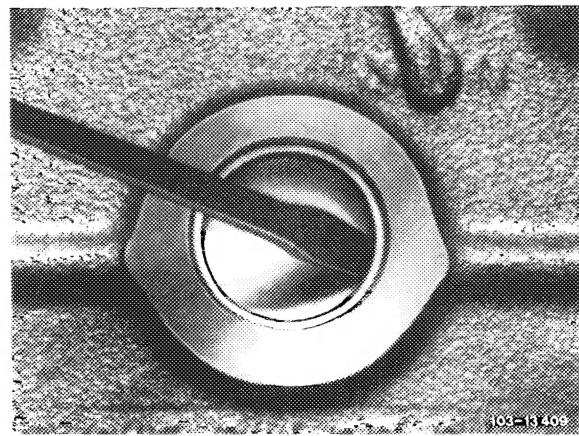
## Replacement

1 Fully drain coolant.

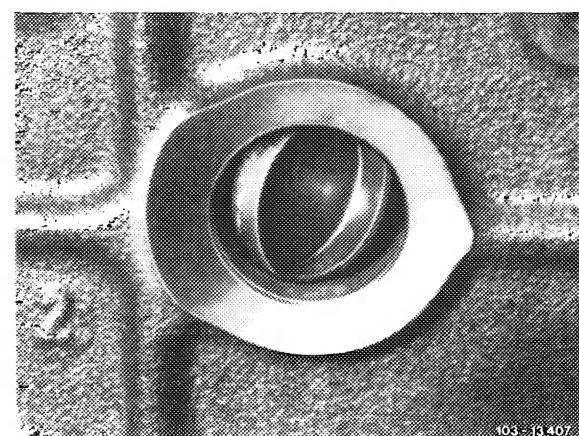
2 Remove assemblies which restrict access (e.g. transmission, intermediate flange, injection pump, etc.).



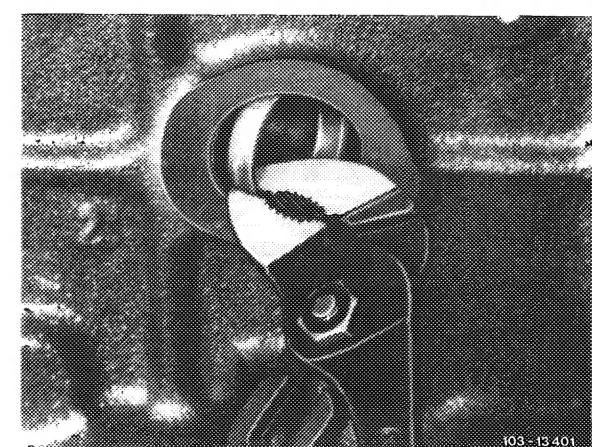
3 Position a fine blade chisel or screwdriver on deep-drawn edge of metal cap.



4 Carefully force cap down at one side until it has turned by about  $90^{\circ}$  about its own longitudinal axis.

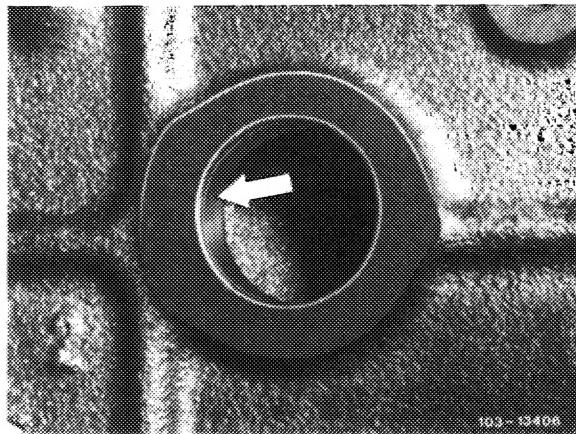


5 Apply a pipe wrench to collar of projecting part and withdraw cap.



6 Thoroughly clean all deposits from core hole. Sealing surface must not show signs of grease (arrow).

7 Coat core hole with sealant, part No. 002 989 94 71.



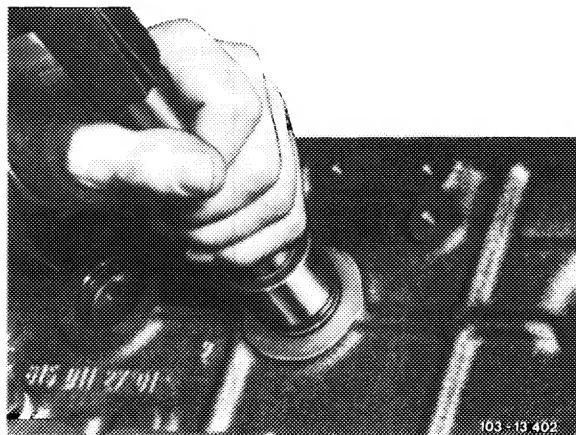
103-13406

8 Insert new cap, using shop-made installer.

9 Attach removed assemblies.

10 Fill with coolant.

**Note:** The sealant must cure for about 45 minutes before system is filled with coolant.



103-13402

11 Warm up engine and check for leakage.

